

Split 2/2

No stock

Work Order ID 139536

139536

Page 1

Thursday, January 21, 2016 10:02:26 AM

Item ID: D3405-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ground Handling Lug

Start Date: 12/29/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/29/2015 Req'd Qty: 12.00

12

Customer:

Reference: 29 arrival

Approvals:

Process Plan: MLS

Date: JAN 21 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.02

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

(29)

02/16/03/02

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(29)

02/16/03/02

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(29)

DAS
38
9-89

MAR 02 2016

Work Order ID 139536

Thursday, January 21, 2016 10:02:26 AM

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Page 2

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ground Handling Lug
Start Date: 12/29/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 12/29/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.01			DAS	29			MAR 03 2016
Brake NC	1-Deburr				30				
	2-Form using DT8204 as per Dwg D3405				9-89				
	3- use DT9681 to check if correct forming								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				29			DAS 30 9-89 MAR 03 2016
Quality Control									
150	Weld per dwg A/R S.S. rod Batch: 126014	0.00							
150									
Large Fab						11			16-03-15
Large Fab	Memo	0.03							JMC
	Weld as per Dwg D3405 use DT8484								
	Identify as D3405-043								

Work Order ID 139536

Thursday, January 21, 2016 10:02:26 AM

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Page 3

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ground Handling Lug
 Start Date: 12/29/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/29/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
						(11)	16-03-16	PD	
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						(11)	16-03-16	PD	
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum m B3962 Memo START TIME: 1:40 OVEN TEMPERATURE: 400° FINISH TIME: 2:10	0.00 0.01							
						11	φ	16-03-17	233

Work Order ID 139536

Thursday, January 21, 2016 10:02:26 AM

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Page 4

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ground Handling Lug
 Start Date: 12/29/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/29/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				11			38 9-09 MAR 18 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: St29 Memo	0.00 0.02				11			DAS 6 9-09 MAR 10 2016
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5			MAR 21 2016 ML5 MAR 21 2016

Picklist Print

Thursday, January 21, 2016 10:02:29 AM

Page 1/1

Work Order ID: 139536

139536

Parent Item: D3405-043

D3405-043

Parent Item Name: Ground Handling Lug

Start Date: 12/29/2015

Required Date: 12/29/2015

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1

Manufactured

No

100

Each

27.0000

1

12

**

D3404-1

GHW/ Lug

Location

WA001

136652

Loc Qty

27

27

Loc Code

150

sf

84.0150

0.154

1.945264

**

M304S11GA

Purchased

No

M304S11GA

304/316 0.125 Sheet

Location

MAT020

M128254

M129545

M129542

Loc Qty

84.01498

24.74

29.37498

29.9

Loc Code

111

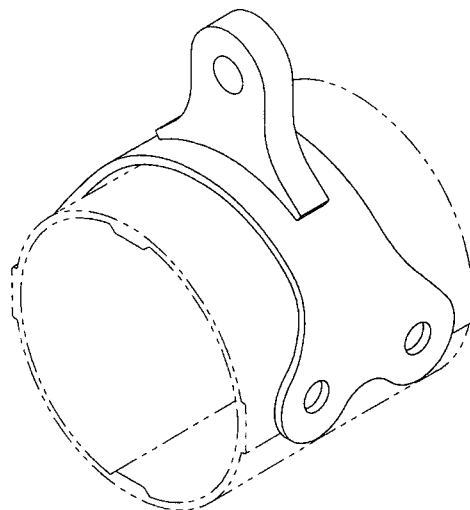
5.5

16-03-15

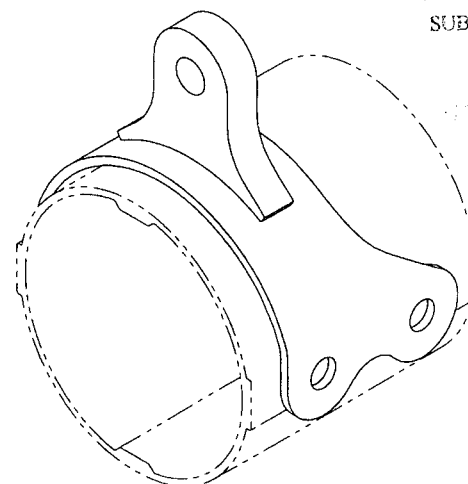
02-16-03-02

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHOP CO
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ON

139,536 MLS

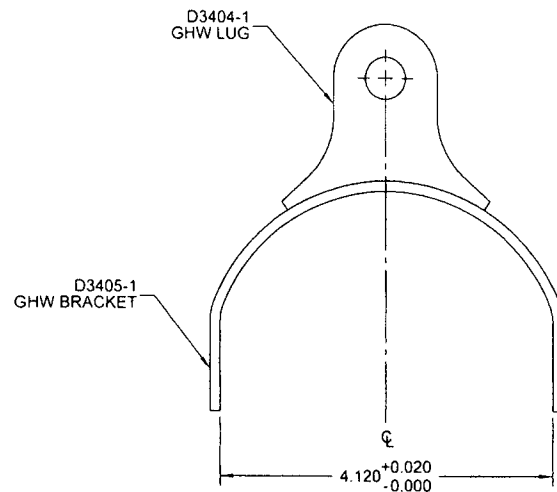
15-12-02

RELEASED
08/12/18 MPT

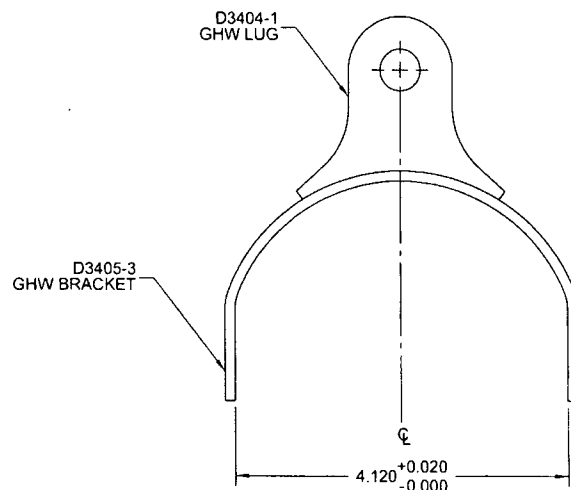
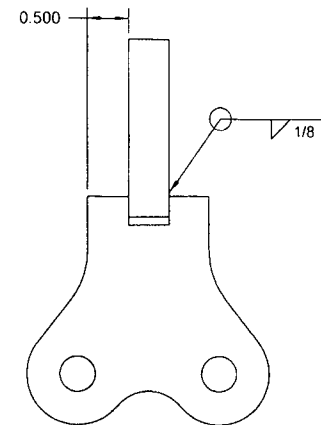
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

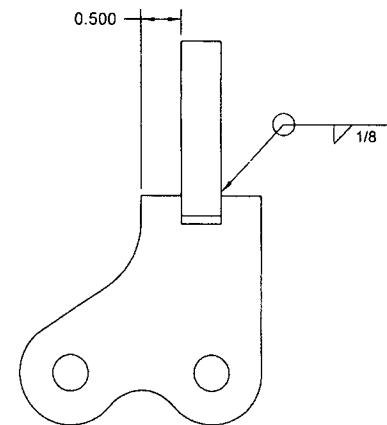
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

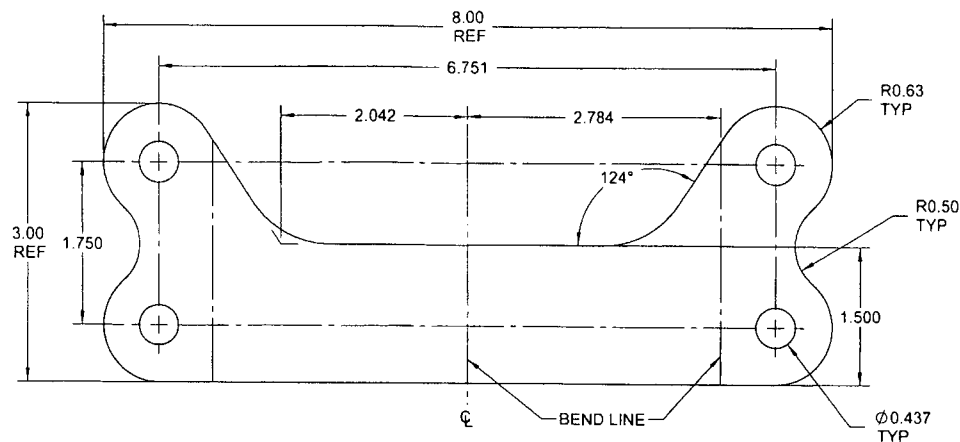
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 2 OF 4
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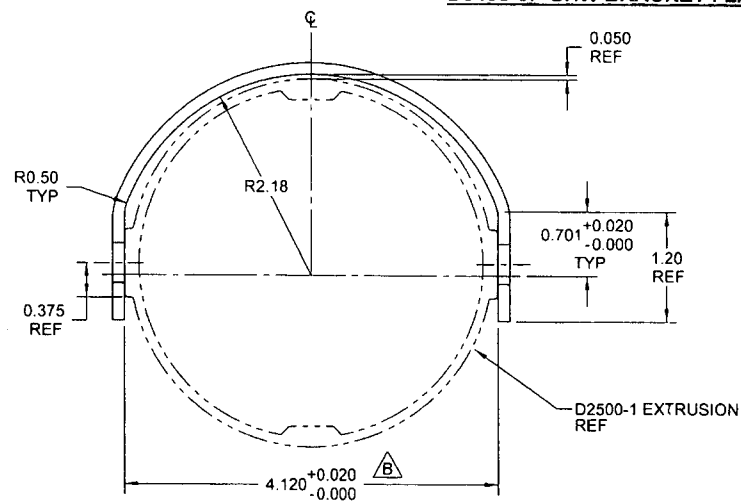
RELEASE
MP-08/12/12

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

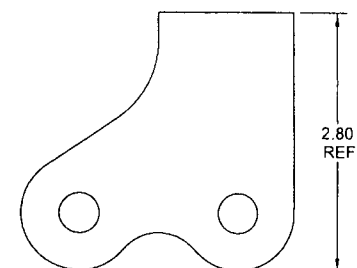
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3405	SHEET 3 OF 4
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DE APPR.		GHW LUG ASSEMBLY	NTS
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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